



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

8609

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12515 ✓	45/50 ✓
2	Machined By		V.T.L. w/o Shop	Dy. Insp. 1.25.2013
3	Pallet Die No.		12807 (6.0) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	620 mm, Step 002 Tapper: 12°	
6	Inside Diameter	Drg. No.	520.12 mm	Step length: 14.5
7	Width of Pellet Die	Drg. No.	222.4 mm	
8	Grooves as per Drawing	Drg. No.	13.2 x 8 x 5 mm / 13.1 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/o Shop	[Tapping No of Holes: 12 Back Side]
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 mm Tapping Depth: 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter: 60

1	Counter Sinking Depth & Finish	ok							low: 23
2	External Relief Dia	6.5 mm	20 Side (3-3)	Inner					
3	External Relief Depth		11 mm	5 mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		25	11	24				

Inspected By (Sign) & Date

Ravi 25/11/24

Satyam 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA